

split

Work Order ID 70581-2

Monday, June 13, 2011 10:26:41 AM



Rush

Item ID: D3179-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Litter Tie Down

Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-06-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3179

Rev C

100

0.00



BAND SAW

0.00

B.A 11/07/08

6 0

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks: 12.150" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

B.A 11/07/22

6 0

HAAS 1

Memo

HAAS CNC vertical machine #1

1- Mill as per Folio FA297 Rev: AA & Dwg D3179-1 Rev: C □ 2-
Deburr per dwg D3179-1

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

B.A 11/07/22

6 0

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 70581

Monday, June 13, 2011 10:26:41 AM

*Post.*

Page 2

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Setup Start



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Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

2L 11-07-25

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

6 0 BR 11-7-25

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

6 0 11-07-25

W/O:		WORK ORDER CHANGES					
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Work Order ID 70581




Monday, June 13, 2011 10:26:41 AM



Page 3

Item ID: D3179-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Fwd Litter Tie Down
Start Date: 6/10/2011 Start Qty: 6.00  Cust Item ID:
Required Date: 6/22/2011 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M117745.</i> Memo START TIME: <i>12:50</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>320°</i> <input type="checkbox"/> FINISH TIME: <i>1:20.</i>	0.00 0.00				<i>6.</i>		<i>162 11-7-25.</i>	
170  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>6 of 1621022</i>	
180  Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3179	0.00 0.00		<i>80 11/6/24</i>		<i>(6)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 70581

Monday, June 13, 2011 10:26:41 AM



Page 4

Item ID: D3179-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Litter Tie Down

Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

m/ 11 07 26 (6)

200



Packaging

Packaging

Identify as per dwg & Stock Location 225

0.00

Memo

0.00

11/24/26 S 6x

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/7/26 S

11-07-26 (6)

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Picklist Print

Monday, June 13, 2011 10:26:49 AM

Page 1

Work Order ID: 70581

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down





Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF
IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP Rev:C 08-12-10 add part list DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																																																																																				
NAS1149D0332J  Washer		Purchased	No			100	Each	2,287.000	3	18																																																																																							
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td colspan="11"></td></tr><tr><td>ST297</td><td>2000</td><td>M118078</td><td colspan="11">18</td></tr><tr><td>117087</td><td>2000</td><td></td><td colspan="11"></td></tr><tr><td>ST298</td><td>287</td><td></td><td colspan="11"></td></tr><tr><td>105793</td><td>12</td><td></td><td colspan="11"></td></tr><tr><td>117291</td><td>275</td><td></td><td colspan="11"></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>												ST297	2000	M118078	18											117087	2000													ST298	287													105793	12													117291	275												
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105793	12																																																																																																
117291	275																																																																																																
D2372  Quick Release		Manufactured	No			180	Each	30.0000	2	12																																																																																							
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td colspan="11"></td></tr><tr><td>ST012</td><td>30</td><td></td><td colspan="11"></td></tr><tr><td>57765</td><td>2</td><td></td><td colspan="11"></td></tr><tr><td>60716</td><td>28</td><td></td><td colspan="11">12</td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>												ST012	30													57765	2													60716	28		12																																						
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57765	2																																																																																																
60716	28		12																																																																																														
D2444  Pip Pin Assembly		Manufactured	No			180	Each	0.0000	1	6																																																																																							
D6201  "T" Extrusion		Manufactured	No			180	f	1.3400	1.0125	6.394737																																																																																							
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td colspan="11"></td></tr><tr><td>MAT004</td><td>1.34</td><td></td><td colspan="11"></td></tr><tr><td>57767</td><td>1.34</td><td></td><td colspan="11">M71208X 6.4</td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>												MAT004	1.34													57767	1.34		M71208X 6.4																																																				
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SS 11/6/20

18

SS 11/6/20

12

SS 11/6/20

SS

M71208X 6.4 and 11/6/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 10:26:49 AM

Page 2

Work Order ID: 70581

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down



Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 6.00

Required Qty: 6.00

MS21042L3

Purchased

No

180

Each

2,290.000

1

6



Nut



SN 11/07/12

Location

Loc Qty

Loc Code

ST300

2290

116391

9

116549

581

117441

800

117601

400

117885

500

MS27039-1-13

Purchased

No

180

Each

44.0000

1

6



Screw



SN 11/07/12

Location

Loc Qty

Loc Code

ST292

44

110844

44

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	70581
Description: Fwd Litter Tie Down Bracket		Part Number:	D3179-1
Inspection Dwg: D3179	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.000	✓		Vern	GA-01
Ø0.242	+0.005/-0.001	Ø0.244	✓		"	"
R0.40	+/-0.030	R0.400	✓		R-G	ref.
0.375	+/-0.010	0.367	✓		Vern	GA-01
Ø0.191	+0.005/-0.001	Ø0.192	✓		"	"
1.00	+/-0.030	0.999	✓		"	"
1.70	+/-0.030	1.700	✓		D-G	GA-08
4.00	+/-0.030	3.993	✓		Vern	GA-01
1.50	+/-0.030	1.497	✓		"	"
0.750	+/-0.010	0.749	✓		"	"
1.50	+/-0.030	1.499	✓		"	"
10.500	+/-0.010	10.500	✓		Vern	CNC-02
4.250	+/-0.010	4.250	✓		Vern	GA-01
0.750	+/-0.010	0.750	✓		"	"
1.000	+/-0.010	0.995	✓		"	"
12.00	+/-0.030	12.000	✓		Vern	CNC-02
1.00	+/-0.030	1.000	✓		"	"
8.00	+/-0.030	8.000	✓		"	"
Ø0.191	+0.005/-0.001	Ø0.192	✓		Vern	GA-01
R0.37	+/-0.030	R0.375	✓		R-G	ref.
0.97	+/-0.030	0.965	✓		Vern	GA-01
1.86	+/-0.030	1.855	✓		"	"
1.750	+/-0.010	1.750	✓		"	"
0.375	+/-0.010	0.371	✓		"	"
2.875	+/-0.010	2.872	✓		"	"
0.500	+/-0.010	0.499	✓		"	"
1.250	+/-0.010	1.251	✓		H-G	3100G
1.625	+/-0.010	1.624	✓		"	"
3.31	+/-0.030	3.313	✓		Vern	GA-01

Measured by:	BA	Audited by:	SL	Prototype Approval:	N/A
Date:	11/07/22	Date:	11-07-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

MS27039-1-13 SCREW
NAS1149D0332J WASHER, 3 PL
MS21042L3 NUT

D2444
PIP PIN

D3179-1 LITTER TIE
DOWN BRACKET

D2372 QUICK
RELEASE
2 PL

 **D3179-041 FWD LITTER TIE DOWN BRACKET**

NOTES:

1) D3179-041 WEIGHT: 2.79 lbs

Item	Qty	Part Number	Description
1	X	D3179-041	FWD LITTER TIE DOWN
2	2	D2372	QUICK RELEASE
3	1	D2444	PIP PIN
4	1	D3179-1	LITTER TIE DOWN BRACKET
5	1	MS21042L3	NUT
6	1	MS27039-1-13	SCREW
7	3	NAS1149D0332J	WASHER (OR AN960JD10L)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70581

2011-06-13

RE-USED
06/11/21

C	ADD D3179-041 & PART LIST (ZN B8-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE PIN	RF	06.11.07
B	REFORMAT DRAWING; FINISH WAS ANODIZE	DC	07.06.06
A	NEW ISSUE	RF	02.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3179	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LITTER TIE DOWN BRACKET	N.T.S
DATE	08.11.07	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>*THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

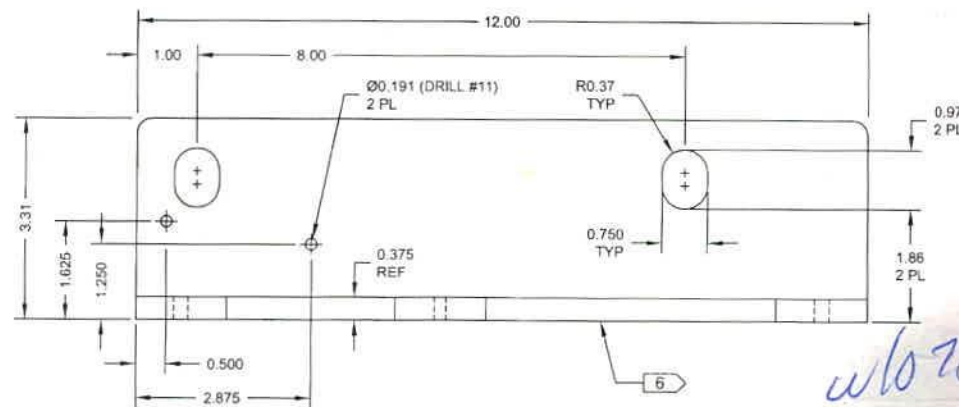
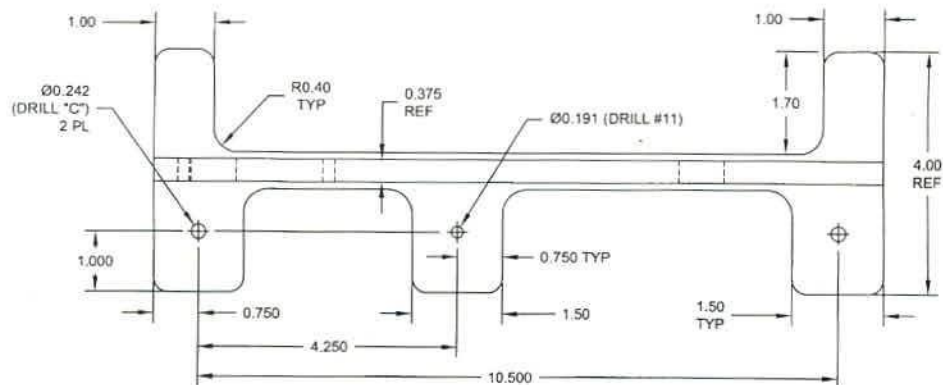
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D3179-1 LITTER TIE DOWN BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T6511 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3179-1 USING FINE POINT PERMANENT INK MARKER ON THE BOTTOM FACE
- 7) WEIGHT: 2.3 lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PL	DRAWING NO.	REV: C
MFG. APPR.		D3179	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	COPYRIGHT © 1995 BY DART AEROSPACE LTD.	

RELEASED
08/11/21

w/070587

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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		1820501						

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